

**Work Order ID 64861**

Monday, December 20, 2010 8:19:14 AM



Page 1

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 12/20/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*Date: *10-12-20*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: *111585*

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: *111585*

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

*SAP 11-01-13**PL 11-01-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 64861

Monday, December 20, 2010 8:19:14 AM



Page 2

Item ID:	D3838-042	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib Assembly (Basket Lid, RH)				Stop	
Start Date:	12/20/2010	Start Qty:	2.00			
Required Date:	12/30/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	Sub 0119			(42)			
						-042			
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00	11-01-18			2	0		BE 11/01/18
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u>  Memo	0.00  0.00	SAD 11-01-19			(2)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 64861**

Monday, December 20, 2010 8:19:14 AM

Page 3

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Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 12/20/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/19 [Signature]  
ME  
11-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, December 20, 2010 8:19:19 AM

Page 1

Work Order ID: 64861

Parent Item: D3838-042

Parent Item Name: Rib Assembly (Basket Lid, RH)



Start Date: 12/20/2010

Required Date: 12/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1  Bushing		Manufactured	No			100	Each	9.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>					
				WA				9					
					54072			9					
M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	937.9064	1.0317	2.172			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT				937.9064					
					112398			0					
					116267			937.9064					
										2.172			



Pl 11-01-18

304421 → (2)



SAD 11-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

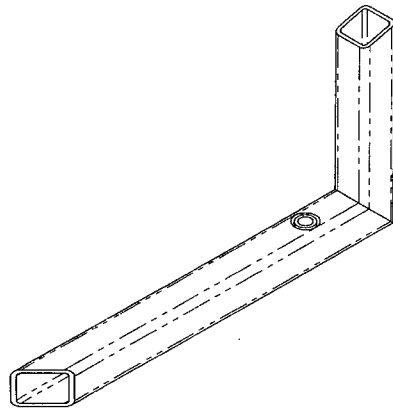
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

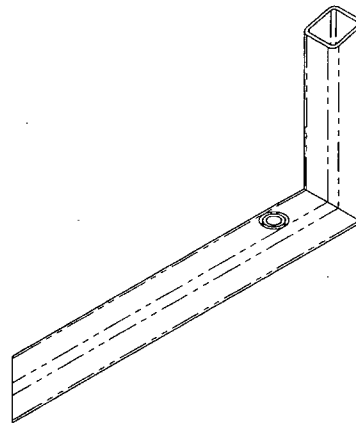
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries





**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1		D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOT COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 6486  
BS 10-12-20

**RELEASED**  
08/11/12

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A  
SHEET 1 OF 3  
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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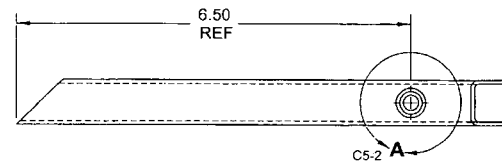
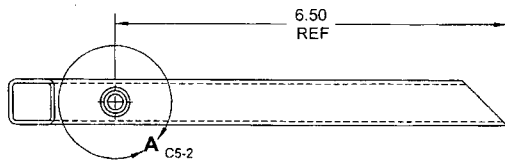
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

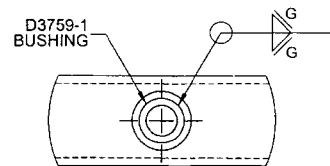
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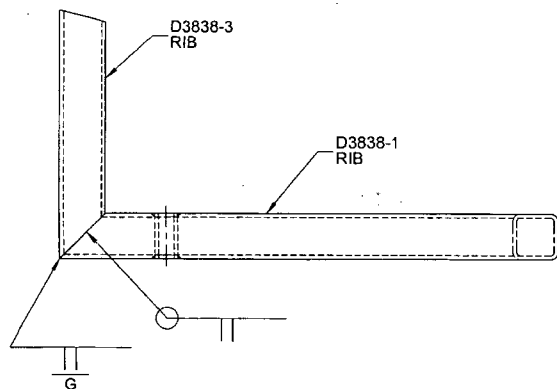
**NOTE:** Date & initial all entries



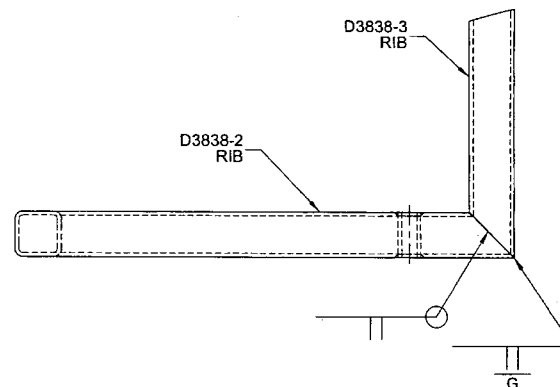
*Wolenski*



**DETAIL A**  
D2-2  
D7-2 SCALE 2X



**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, LH)**

**RELEASED**  
*08/10/14*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SS</i>	DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.	<i>MD</i>	TITLE	SHEET 2 OF 3
APPROVED	<i>MD</i>	<b>RIB ASSY (BASKET LID)</b>	SCALE
DE APPR.			NTS
DATE	<b>08.10.08</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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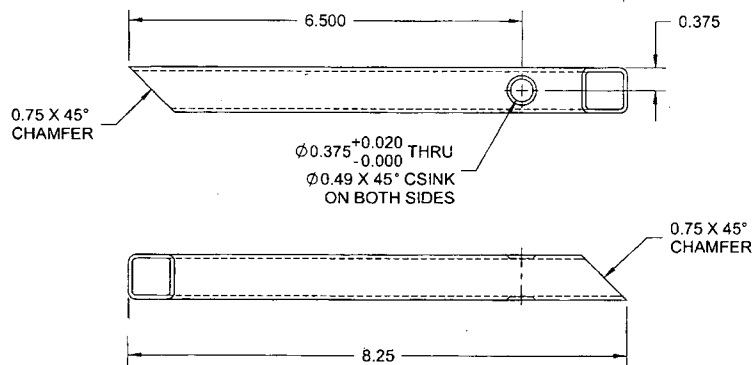
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

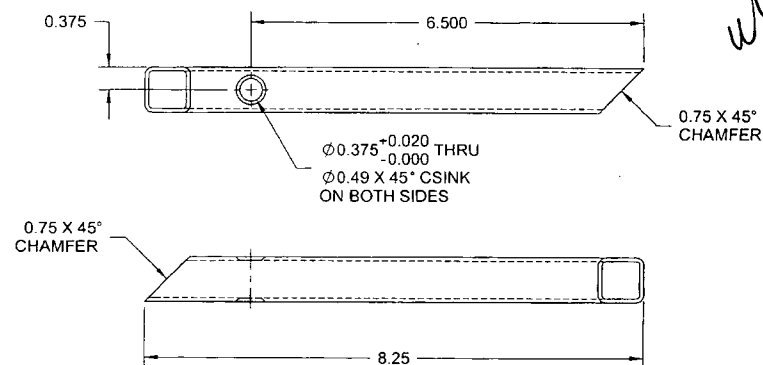
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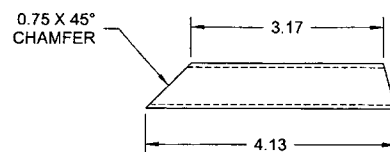
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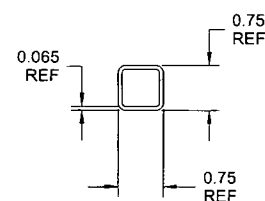
**D3838-1 RIB**



**D3838-2 RIB**



**D3838-3 RIB**



**TYPICAL SECTION VIEW**

*whole set*

**RELEASED**  
28/11/14

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3838	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

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